

Work Order ID 130514

130514

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Friday, March 13, 2015 12:55:42 PM

Item ID: D4074-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 3/13/2015 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 3/13/2015 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 1503-13 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4074	C								

100 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg
 6061-125 Dwg Rev: C
 Prog Rev: C
 2-Deburr if necessary
 110 0.00
110
 QC Memo 0.00
 Quality Control

(14) 02/15/03/22
 (14) 02/15/03/22

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Item ID: D4074-1 Accept ***N900040100*** Setup Start ***NS1***
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 Required Date: 3/13/2015 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150						14	1	15-3-31	DOY J4
HandFinish	Memo	0.00							
Hand Finishing									
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
160	M 131545.					14	0	15-4-2	DAS 34 9:89
Powdercoat	Memo	0.00							
Powder Coating	POWDER COAT: Start Time: 8:10 Oven Temperature: 320° Finish Time: 8:40.								
170	QC3- Inspect Part Finish	0.00							
170						14			DAS 38 9:89
QC	Memo	0.00							
Quality Control									

APR 02 2015

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 3/13/2015 **Start Qty:** 12.00

12

Cust Item ID:

Required Date: 3/13/2015 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

180

Identify as per dwg & Stock Location:

0.00

180

Packaging

Memo

0.00

Packaging

DAS
27
9-80
APR 02 2015

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ 150407

MS-4-2

Picklist Print

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Work Order ID: 130514

130514

Parent Item: D4074-1

D4074-1

Parent Item Name: Bracket

Start Date: 3/13/2015

Required Date: 3/13/2015

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 10.06.08 new issue DD verf:EC
AS PER ECN 11-613 11-07-25 JLM VERIFIED BY:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	110.4395	0.0452	1			

M6061T6S 125

6061-T6 .125 Sheet

02/15/03/22

Location

Loc Qty

Loc Code

MAT020

110.43945

m127454

1.75

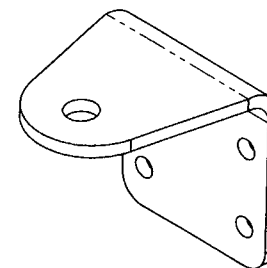
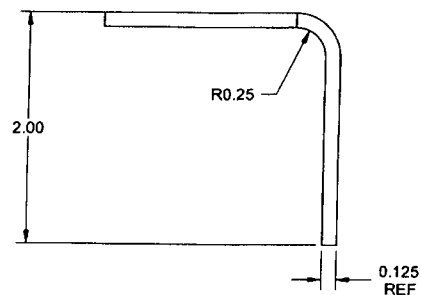
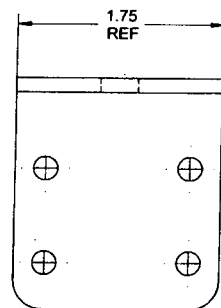
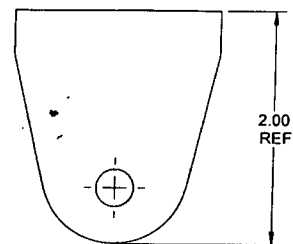
m130745

18.68945

m131352

90

1



D4074-1 BRACKET
(MAKE FROM D4074-1F FLAT PATTERN)

NOTES:

- 1) MATERIAL: MAKE FROM D4074-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs

130S14 MWS
1503-13

RELEASED
R 2011-10-26
JW

C	MODIFY -7 STRIKER PLATE, SHEET 6 AND 7	HS	11.10.12
B	Ø 0.173 WAS Ø 0.129 (ZN B3-4); 1.28 WAS 0.90 (ZN C4-6); 1.93 WAS 1.55 (ZN C2-7); 2.10 WAS 1.72 (ZN C1-7)	RF	11.03.07
A	NEW ISSUE	HS	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D4074	SHEET 1 OF 7
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BRACKET	NTS
DATE	11.10.12	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

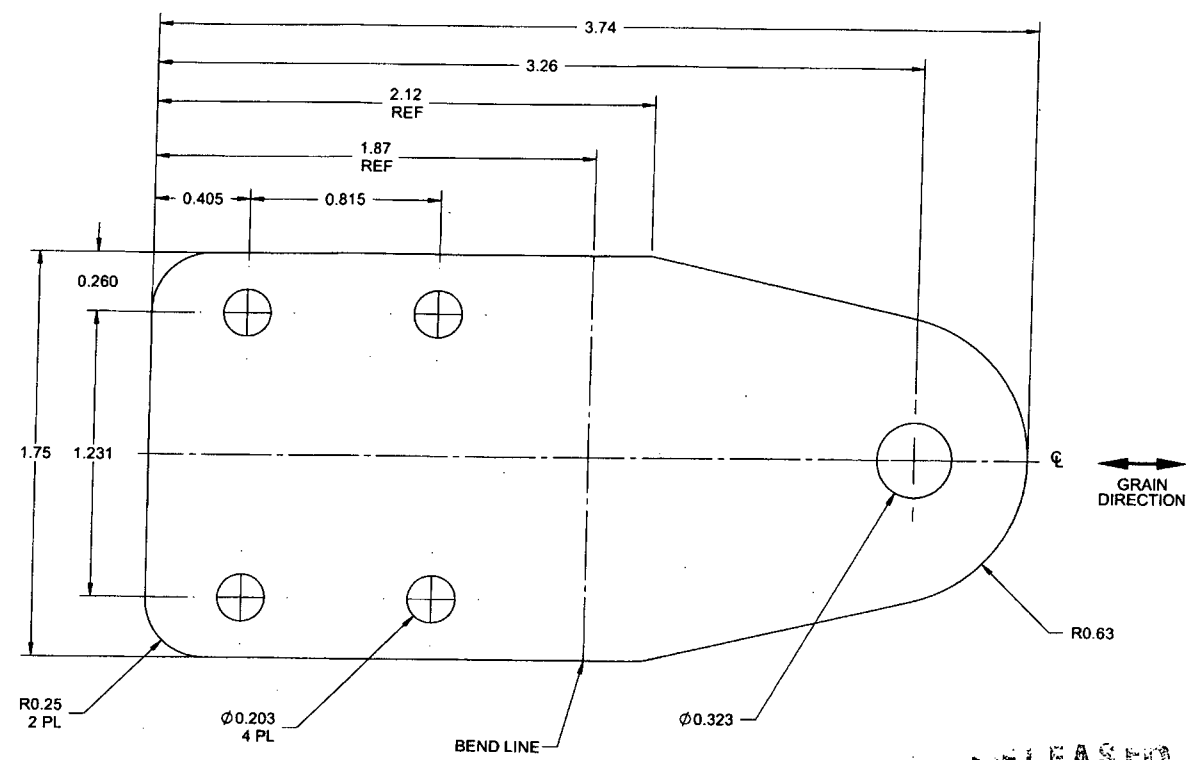
8 7 6 5 4 3 2 1

D

C

B

A



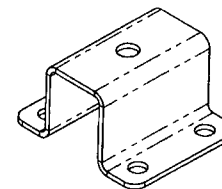
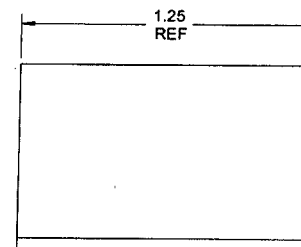
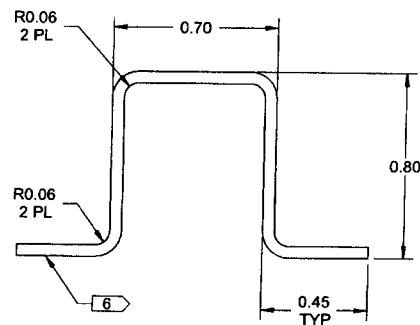
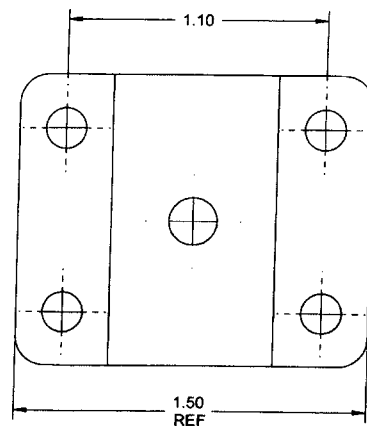
D4074-1F FLAT PATTERN

RELEASED
2011-10-26

- NOTES:**
 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK
 PER QQ-A-250/11 OR AMS-QQ-A-250/11
 OR AMS 4025 OR AMS 4027
 OR ASTM B209
 REF DART SPEC M6061T6S.125
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 0.07 lbs
 8) PART IS SYMMETRICAL ABOUT CENTERLINE

DESIGN	RF	DART AEROSPACE USA, INC.	
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CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D4074	SHEET 2 OF 7
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8 7 6 5 4 3 2 1



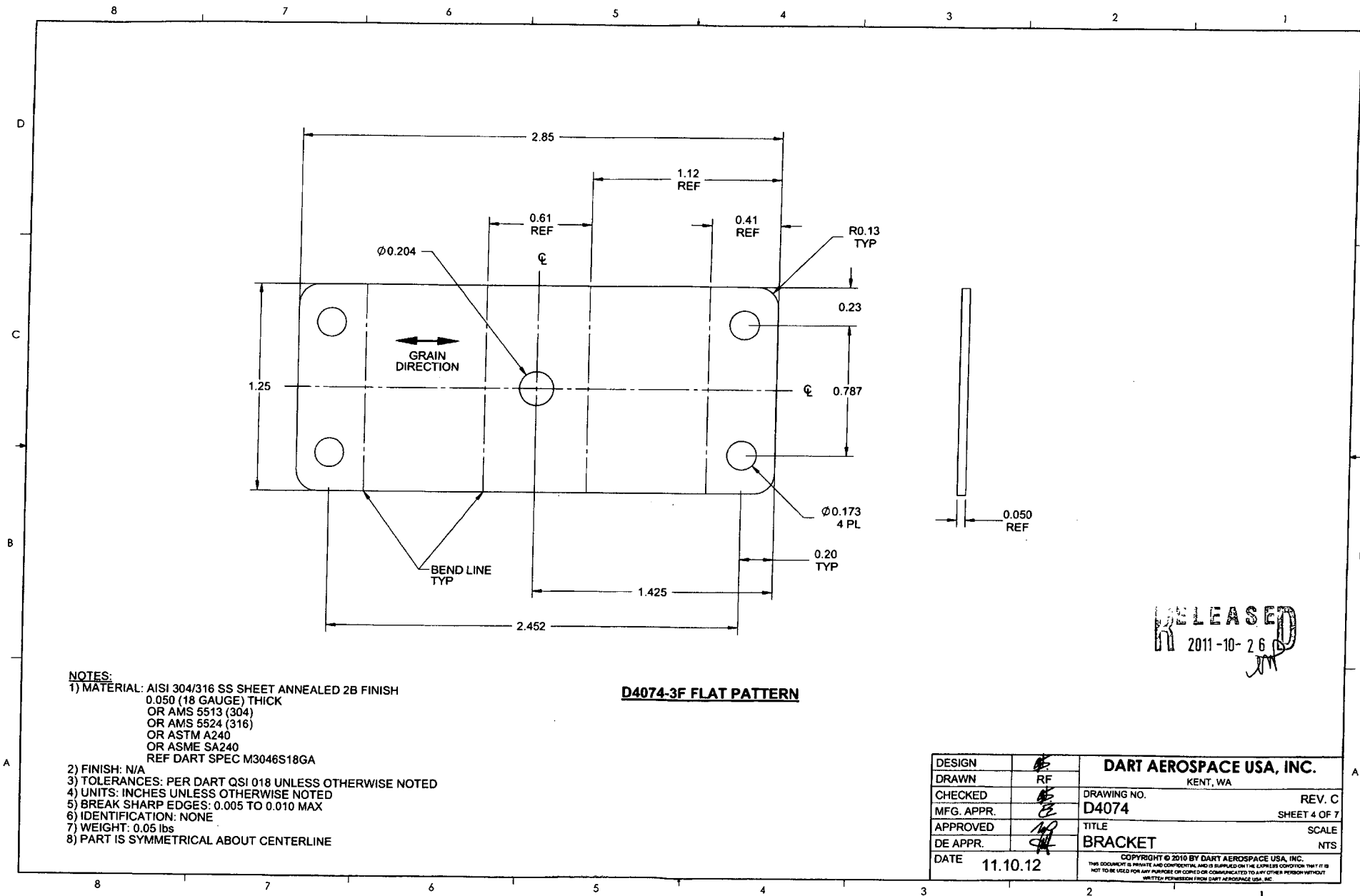
D4074-3 CHANNEL
(MAKE FROM D4074-3F FLAT PATTERN)

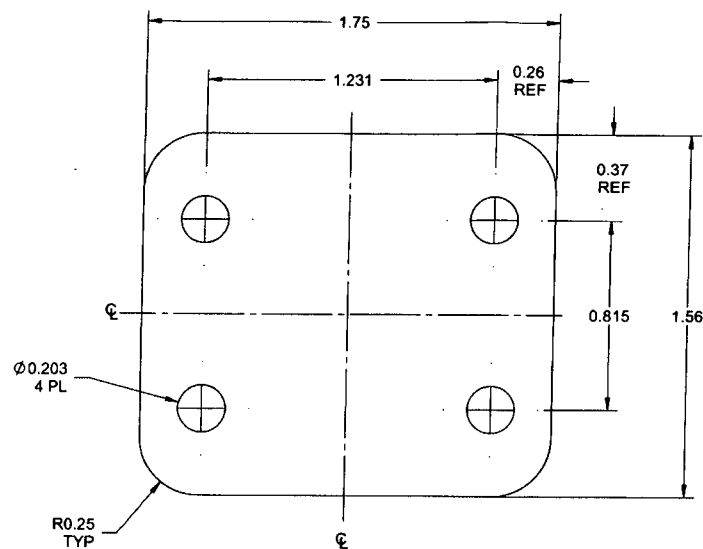
RELEASED
2011-10-26
JN

NOTES:

- 1) MATERIAL: MAKE FROM D4074-3F FLAT PATTERN
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

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MFG. APPR.	RF	D4074	SHEET 3 OF 7
APPROVED	RF	TITLE	SCALE
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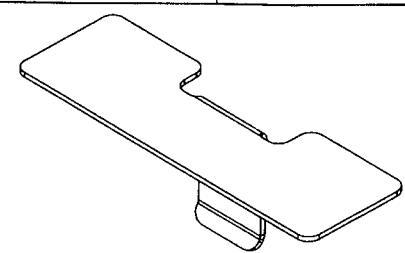
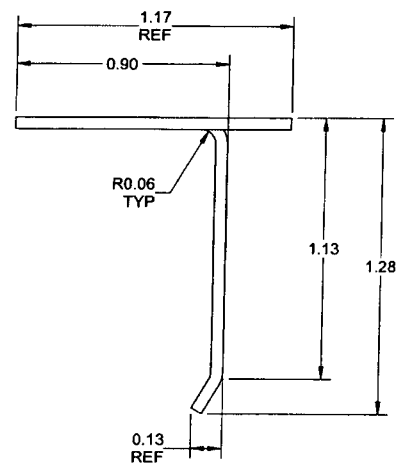
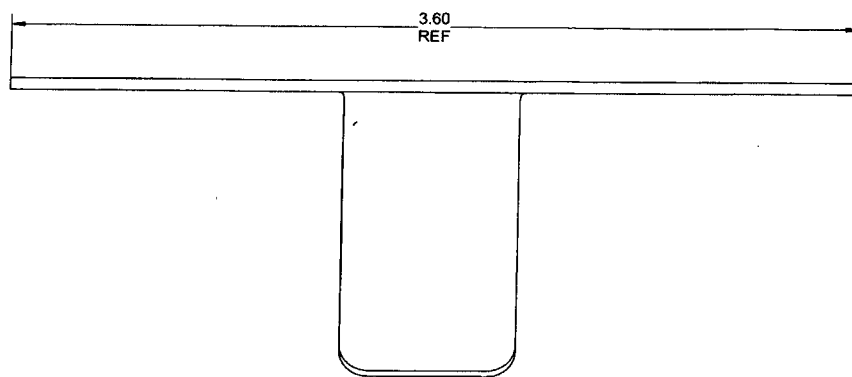
D4074-5 BACKING PLATE

RELEASED
2011-10-26

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

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MFG. APPR.		D4074	SHEET 5 OF 7
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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D4074-7 STRIKER PLATE
(MAKE FROM D4074-7F FLAT PATTERN)

RELEASED
2011-10-26

- NOTES:**
- 1) MATERIAL: MAKE FROM D4074-7F FLAT PATTERN
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: PER QSI 044 6.1
 - 7) WEIGHT: 0.07 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D4074	SHEET 6 OF 7
APPROVED	RF	TITLE	SCALE
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